Work Order ID 78919

January-17-12 9:01:08 AM

78919

Item ID: D3886-1

Revision ID:

Item Name: Lug

Start Date: 17/01/2012 **Start Qty:** 6.00 *6*

Required Date: 31/01/2012 **Req'd Qty:** 6.00 *6*

Reference:

Accept *N900040100*

Setup **Start** *NS1* **Stop** *NS2*

Cust Item ID:

Customer:

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Run **Start** *NR1* **Stop** *NR2*

Draw Nbr	Revision Nbr
D3886	B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Bandsaw Jeaspa Bandsaw	Memo BAND SAW Cut blanks: 2.50" x 0.500" x 2.250" long	0.00 / 0.00	JK 12/05/08			6	ø		
110 *110* HAAS 1 HAAS CNC vertical machine #1	Memo HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA812 and Dwg D3886 Identify as D3886-1 Dwg Rev B Folio Rev AA	0.00 / 0.00	JL 12-05-09			6	ø		
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 / 0.00	JL 12-05-09			6	ø		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Item ID: D3886-1
Revision ID:
Item Name: Lug
Start Date: 17/01/2012 **Start Qty:** 6.00 *6*
Required Date: 31/01/2012 **Req'd Qty:** 6.00 *6*
Reference:

Accept *N900040100*
Setup **Start** *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run **Start** *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check	0.00	B.A 12/05/10			6	∅		
	Memo	0.00							
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: WA	0.00			12/5/10	6			
	Memo	0.00							
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00				12/5/14			
	Memo	0.00							

MLJ 12/05/11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Picklist Print

January-17-12 9:01:13 AM

Work Order ID: 78919 *78919*

Parent Item: D3886-1 *D3886-1*

Parent Item Name: Lug

Start Date: 17/01/2012 **Required Date:** 31/01/2012

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X2.500 *M304B0.500X2.500* 304 BAR .500 x 2.50		Purchased	No			100	f	44.9970	1.87 **	11.81053			

Location	Loc Qty	Loc Code	
MAT050	44.997		
112764	8.312		1.87 12/05/08
116135	0.375		
117685	4.4		
119231	31.91		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______ **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes No **DQA:** ______ **Date:** ______

Resolution: ______ **Disposition:** ______ **QA: N/C Closed:** ______ **Date:** ______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	78919
Description: Lug	Part Number:	D3886-1
Inspection Dwg: D3886 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.65	+/-0.030	.651	✓		Vern	JL-10
1.11	+/-0.030	1.108	✓			
1.95	+/-0.030	1.960	✓			
0.060	+/-0.010	.065	✓			
Ø0.510	+0.008/-0.001	.510	✓			
0.06 x 45°	+/-0.030 x +/-0.5°	.052X45°	✓			
0.375	+/-0.010	.377	✓			

Measured by:	JL	Audited by:	H.A	Prototype Approval:	N/A
Date:	12-05-09	Date:	12/05/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ________________ **PAR #:** ______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** ____ **Date:** ________

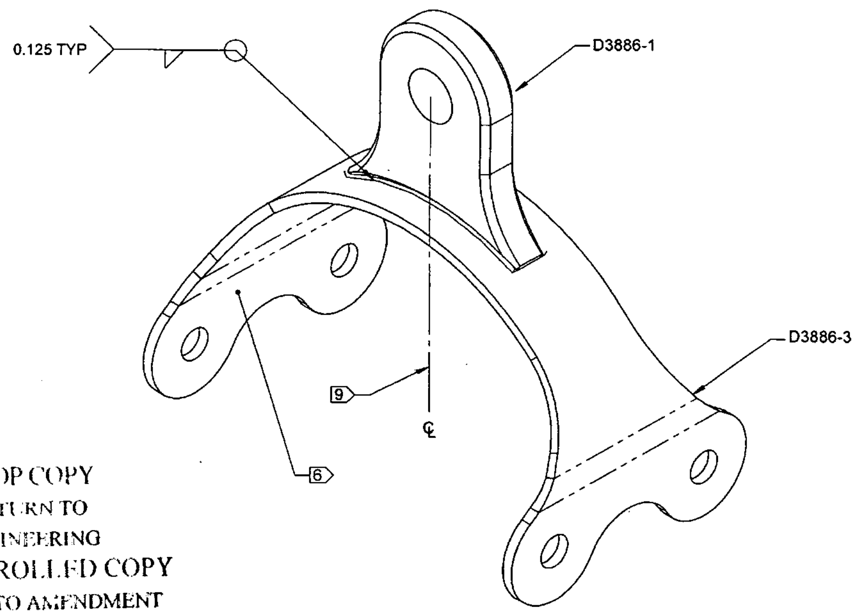
Resolution: ________________ **Disposition:** ________________ **QA: N/C Closed:** ________ **Date:** ________

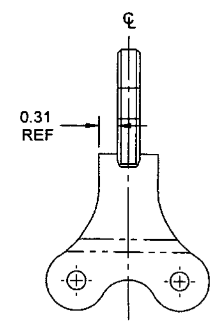
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3886-041	LUG ASSEMBLY
2	1	D3886-1	LUG
3	1	D3886-3	BRACKET





SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78919 M.L.J 12/01/17

D3886-041 LUG ASSEMBLY

RELEASED

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3886-041" AND BATCH NUMBER USING FINE POINT PERMANENT INK MARKER ON UNDERSIDE OF PART
7) WEIGHT: 0.53 lbs
8) WELD PER DART QSI 004
9) BOTH PARTS CENTER SHOULD BE IN LINE WITH THE ℄

REV.	DESCRIPTION	BY	DATE
B	RE-DESIGN D3886-1 (ZN B4-2); RE-DESIGN D3886-3 (ZN A4-3); REVISED D3886-3F (ZN B4-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	RF	
CHECKED		DRAWING NO. D3886 — REV. B — SHEET 1 OF 4
MFG. APPR.		
APPROVED		TITLE LUG ASSEMBLY — SCALE NTS
DE APPR.		
DATE	09.06.30	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

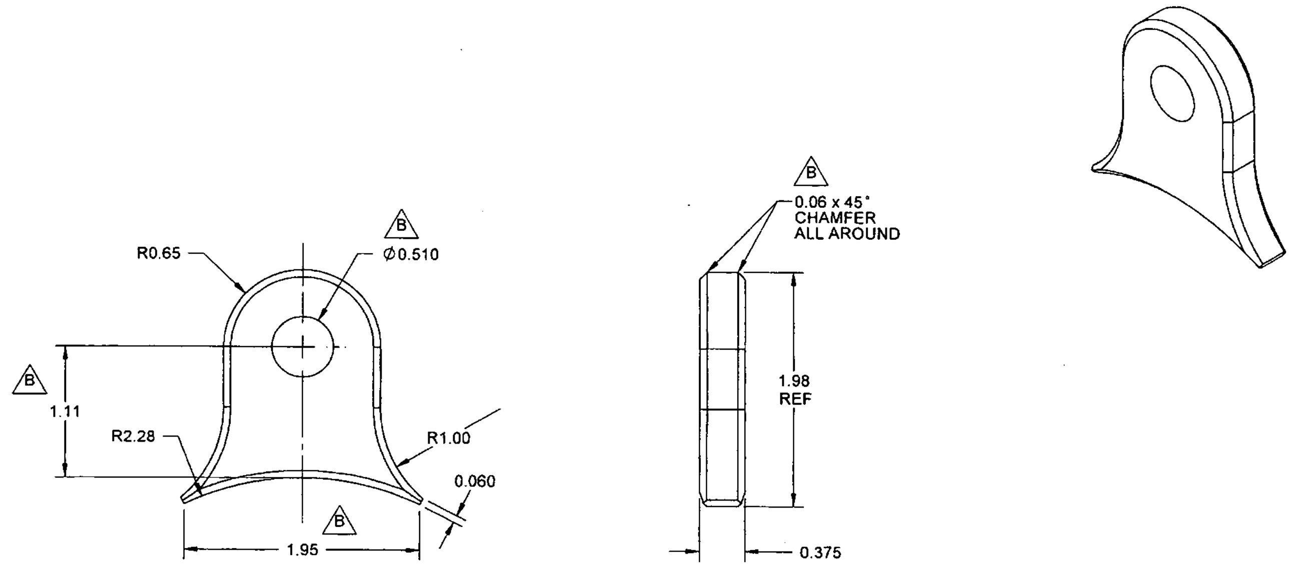
Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78919



D3886-1 LUG B

RELEASED 09/01/15

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.23 lbs

DESIGN	RF	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	RF	
CHECKED	[signature]	DRAWING NO. D3886 — REV. B — SHEET 2 OF 4
MFG. APPR.	[signature]	
APPROVED		TITLE LUG ASSEMBLY — SCALE NTS
DE APPR.	[signature]	
DATE	09.06.30	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

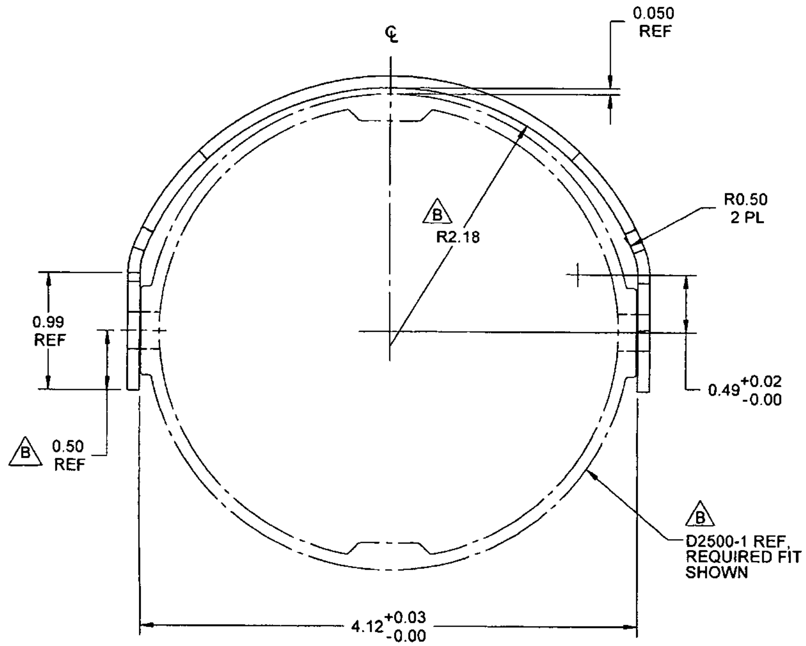
Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

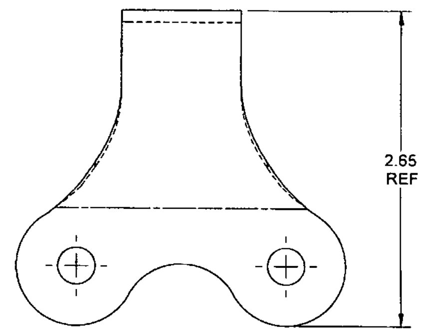
Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

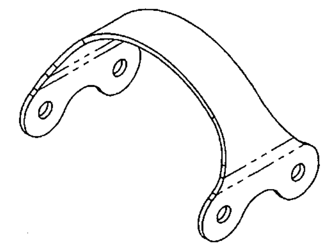
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

78919







RELEASED 09/07/15

D3886-3 BRACKET (B)
(MAKE FROM D3886-3F)

DESIGN	RF	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	RF	
CHECKED	[signature]	DRAWING NO. D3886 — REV. B — SHEET 3 OF 4
MFG. APPR.	[signature]	
APPROVED		TITLE LUG ASSEMBLY — SCALE NTS
DE APPR.	[signature]	
DATE	09.06.30	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

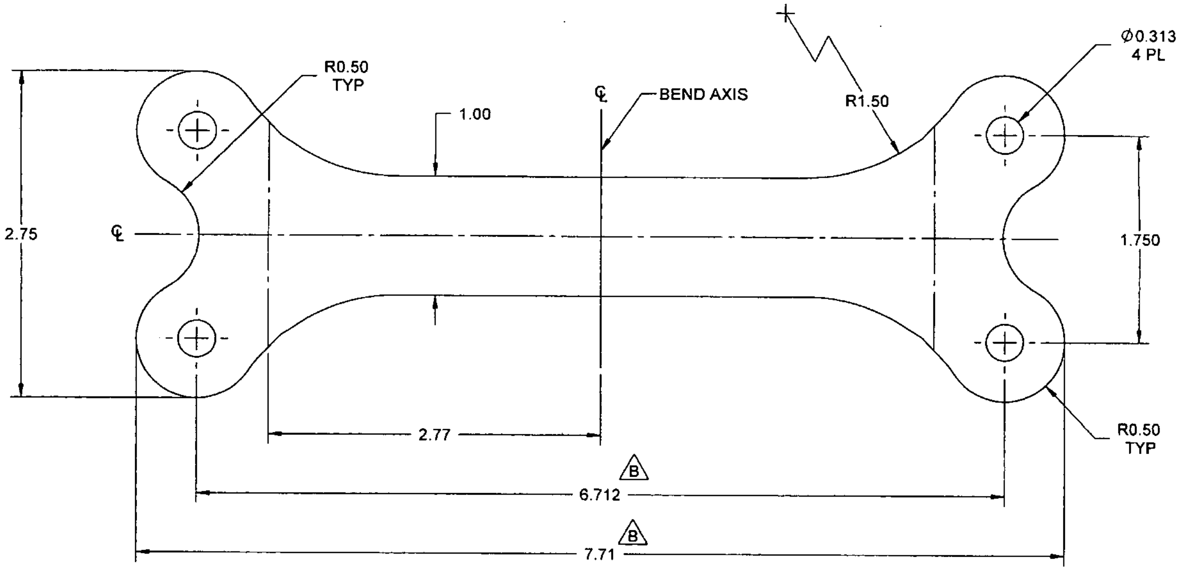
Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78919



D3886-3F FLAT PATTERN B

RELEASED

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 12 GAUGE (0.100) THICK, (REF. DART SPEC. M304S12GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.30 lbs

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	RF	
CHECKED		DRAWING NO. D3886 REV. B SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE LUG ASSEMBLY SCALE NTS
DE APPR.		
DATE	09.06.30	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries